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D3537-3

Job Sheet 200669



Part No: D3537-3

Job Qty: 8 pcs

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/1/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3537 REV.F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 AUTOMATED PROCESS DD
VERF:JLM IPP REV:C 18.11.09 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		10/11/19	0.17	0.48	Waterjet - Flow		02/19/10/02
120	QC 8	8 pcs		10/11/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
130	Small Fab - Brake NC - B4B	8 pcs		10/11/19	0.25	0.37	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		

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				B4B	
				Small Fab - Brake - 3 - B4B	OCT 03 2019
140 QC 5	8 pcs	10/11/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	81
				QC 5 - 40	9-89
				QC 5 - 61	
				QC 5 - 81	
150 Automated Welding - B4B	8 pcs	10/11/19	0.00 0.71	Automated Welding - 1 - B4B	ML
160 QC 10	8 pcs	10/11/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
170 QC 5	8 pcs	10/11/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
200 Packaging 3-1 - Stock - B4B	8 pcs	10/11/19	0.00 0.00	Packaging 3 - 1 - B4B	FD 001 ML 19-10-2
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				210 QC 21 - SA	8 pcs	10/11/19	0.00 0.00	QC 21 - SA - 21	
								QC 21 - SA - 70	DAS
								QC 21 - SA - 53	21
								Broussard	9-89 OCT 09 2019

Part Op 100 - 1-Cut D3537-3 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Debur if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Automated welding) ****SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR
 AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M139018
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: see below)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.1920 sf (.149 ea)	100-Waterjet - Flow - 1	S207058

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	473	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	5.859inches $\pm$ 0.010	5.869 5.849		
2	Wearpad	3.500inches $\pm$ 0.010	3.510 3.490		
3	Wearpad	1.965inches $\pm$ 0.010	1.975 1.955		
4	Wearpad	2.795inches $\pm$ 0.010	2.805 2.785		
5	Wearpad	3.625inches $\pm$ 0.010	3.635 3.615		
6	Wearpad	0.220inches $\pm$ 0.010	0.230 0.210		
7	Wearpad	0.380inches $\pm$ 0.010	0.390 0.370		
8	Wearpad	0.063inches $\pm$ 0.010	0.073 0.053		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Undeclared Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					